



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4151-5
Job Sheet 169300



Part No: D4151-5

Job Qty: 20 ea

Part Name: Fwd Basket Instl Stud



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/6/17

Job Tracking No:

Due Date: 12/19/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	12/18/17	12/18/17	0.00	0.00	Start Up Machining-2		
110	Doosan	20 pcs	12/19/17	12/19/17	0.01	6.41	Doosan		
130	QC	20 pcs	12/19/17	12/19/17	0.00	0.00	QC8		
140	Packaging	20 pcs	12/19/17	12/19/17	0.00	0.00	Packaging3-2		
150	QC21-SA	20 Ea	12/19/17	12/19/17	0.00	0.00	QC21		

Part Op
Descriptions: 110 - 1-Mill as per folio FA953 & dwg ,

DEC 19 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M303R1.000	5	16	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fwd Basket Inst. Stud (Lower)	1.000Inches ± 0.030	1.030 0.970	Diameter	
2	Fwd Basket Inst. Stud (Lower)	0.800Inches + 0.000 - 0.010	0.800 0.790		
3	Fwd Basket Inst. Stud (Lower)	0.750Inches + 0.030 - 0.000	0.780 0.750		
4	Fwd Basket Inst. Stud (Lower)	0.375Inches ± 0.010	0.385 0.365		
5	Fwd Basket Inst. Stud (Lower)	0.500Inches ± 0.030	0.530 0.470		
6	Fwd Basket Inst. Stud (Lower)	1.000Inches + 0.003 - 0.000	1.003 1.000		
7	Fwd Basket Inst. Stud (Lower)	2.000Inches ± 0.030	2.030 1.970		
8	Fwd Basket Inst. Stud (Lower)	2.880Inches ± 0.030	2.910 2.850		
9	Fwd Basket Inst. Stud (Lower)	0.250Inches ± 0.010	0.260 0.240		
10	Fwd Basket Inst. Stud (Lower)	0.438Inches + 0.000 - 0.010	0.438 0.428	Diameter	
11	Fwd Basket Inst. Stud (Lower)	0.130Inches ± 0.030	0.160		

4' + 4' dans machine

138889 M/38389

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2017 05 1.001

5hrs
LUC

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

12	Fwd Basket Inst. Stud (Lower)	0.060inches $\pm$ 0.030	0.090	Radius	0.100
13	Fwd Basket Inst. Stud (Lower)	0.250inches + 0.003 - 0.000	0.253	Diameter	0.250
14	Fwd Basket Inst. Stud (Lower)	0.130inches $\pm$ 0.030	0.160	Radius	0.100

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



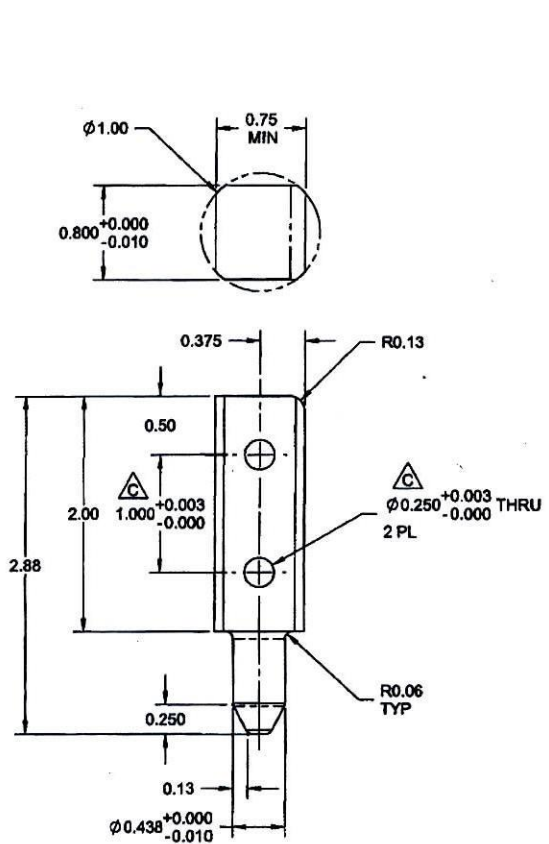
QA Closed: _____ Date: _____

Work Order update only ☐

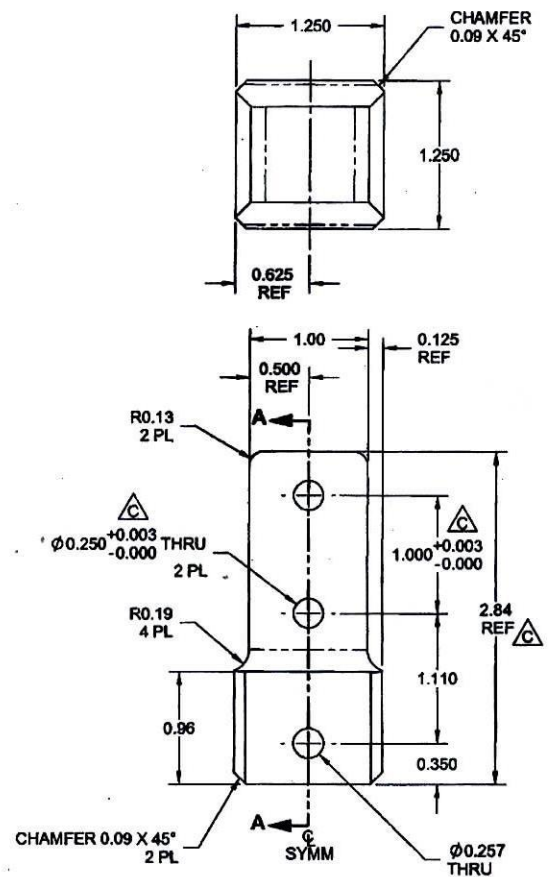
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

FIRST ARTICLE INSPECTION CHECKLIST

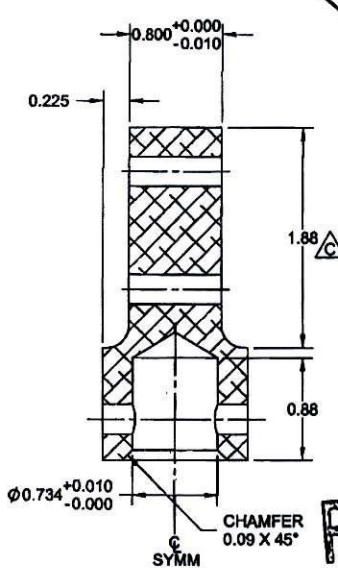
Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	11.04.28	Dimensions updated per Dwg Rev C	KJ	



D4151-5 FWD BASKET INSTL STUD (LOWER)



D4151-7 FWD EYEBOLT RECEIVER (UPPER)



SECTION A-A

- NOTES:**
- 1) MATERIAL - 5: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582 PER DART SPEC M303R OR M304R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
 - 7) WEIGHT - 5: 0.36 lbs
- 7: 0.70 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	Sc	DRAWING NO.	REV. C
MFG. APPR.		D4151	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET FWD HARDPOINT	NTS
DATE	10.12.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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2011-03-30
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AEROSPACE
S022094

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Fwd Basket Instl Stud

PART NO: D4151-5
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 12/14/17

Job No: 169300